

Date: Wednesday, 9/12/2007 12:13:07 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING	
Job Number	: 34593				
Estimate Number	: 10725				
P.O. Number	: N/A		Part Number	: D2652	
This Issue	: 9/12/2007	S.O. No. : N/A	Drawing Number	: D2652 REV A	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 34348		Material	: N/A	
Written By			Due Date	: 10/5/2007	
Checked & Approved By			Qty:	200	
Comment	: Est Rev:B 02.06.13 Now machined in house.		Um:	500	
NG					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0500	303 Round Bar 0.500"
	Comment: Qty.: 0.0578 f(s)/Unit Total : 28.8750 f(s) Material:303 ss .500" Round Bar (M303R0500) Batch: M105556	DSP 07/09/16
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	Comment: HARDINGE CNC LATHE SMALL	
	1-Turn as per Folio FA250 & Dwg D2652	
	2-Deburr	DSP 07/09/16
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	DSP 07/09/16
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	JUL 07.09.17
5.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	7/9/17
		200x S0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/09/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 34593

Part Number: D2652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



260

Comment: FINAL INSPECTION/W/O RELEASE

10/09/18

Job Completion



Colo 7/09/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 34593

**Description:** Bushing

Part Number: U2634

Inspection Dwg: D2652 Rev: A

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	0.6015	✓			
0.060	+/-0.005	0.0625	✓			
Ø0.305	-0.002/+0.000	Ø0.304	✓			
Ø0.191	+0.005/-0.000	Ø.1945	✓			
Ø0.500	+/-0.010	0.50	✓			
0.030 x 20°	+/-0.010	0.30 x 20°	✓			
R0.010	+0.010/-0.000	0.010	✓			

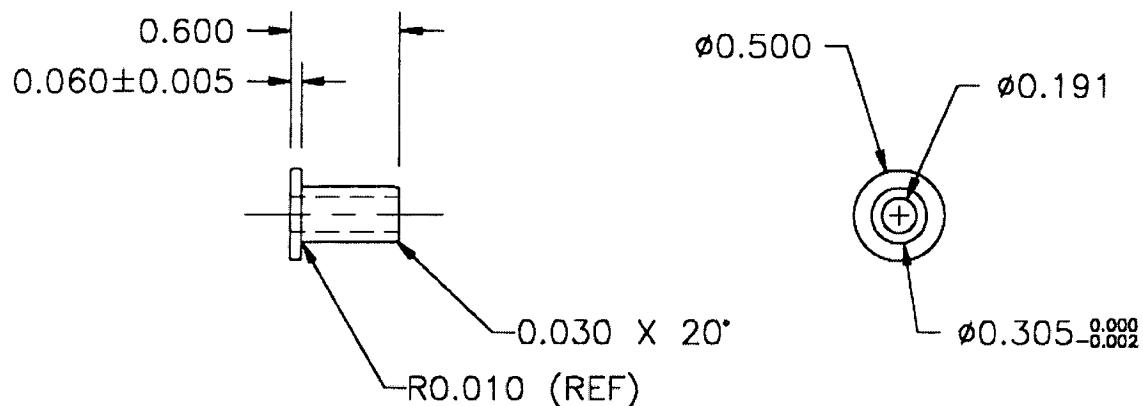
Measured by: DJR  
Date: 07/09/16

Audited by: J.L.  
Date: 07/09/16

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.12.12	New Issue	KJ/RF	TH

**DART**

DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>B</i>	APPROVED <i>DMY</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

**RELEASED**  
97/04/25 DS

MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. *34593*